

Work Order ID 163173

Thursday, June 22, 2017 10:20:32 AM

*163173

Item ID: D350-636-012

Accept

*N9000401

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUN 22 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-042	G
D3492	E

DAS
6

AUG 10 2017

100

Document Control

9-89

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.8

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
28
9-89

AUG 10 2017

B163173R+1

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

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110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ✓

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig, DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. (VERIFY AND RECORD FWD BEND ANGLE.)

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

0.15

17-06-28
DJ17-06-29
DJ

BE17-07-03

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Stop ***NR2***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: m136920

9- Grind welds flush as per Dwg D2750

78E17-07-03

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

JUL 04 2017

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.02

Quality Control

DAS

38

9-89

JUL 04 2017

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00				1		17-07-11	
140									
HandFinish	Memo	0.70							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00				1	0	17-07-11	
150									
QC	Memo	0.01							
Quality Control									

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160

0.00

160

Skidtubes

0.93

Skidtubes

Memo

Skidtubes

1- Open up holes of Detail L using hole saw and ground handling to 0.625"
(total of 8 holes per side) as per dwg D2750.2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750
(welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 137127

exp. date: 17-09-26

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 9)

A/R Aluminum Rod

batch: m137133

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

13h

17-09-26

17-07-12
D.Y.

> 17-07-13

17-07-13

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11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.02

Quality Control

VERIFY C'BOARD IS GOOD

17-07-13
JITDAS
38
9-89

JUL 21 2017

DAS
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JUL 21 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.41							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								2017/07/28 BEB
200	Spray Painting per QSI005 4.2	0.00							
200									
SprayPaint	Memo	0.43							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>137195</u>								DAS 41 9-89 JUL 30 2017
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>137852</u>								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								IRM of Jll 17/08/08 DAS 15 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Assemble as per dwg HandFinishing	0.00							
230	HandFinish	Memo							
Hand Finishing	1-Install inserts as per dwg D2750	1.11							
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M1137446</u> EXP DATE: <u>18/03</u> 1250598 M1137747 18k								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M1135477</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M132690</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	Memo							
Quality Control		0.02							

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 Reference:

N900040100

Setup Start *NS1*
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Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.03							
Quality Control									
270	Identify as per dwg & Stock Location:	0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012 Location : FG072								

DAS 6 27 9-89 AUG 10 2017

DAS 28 9-89 AUG 10 2017

DAS 27 9-89 17/8/11

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280							DAS 21 9-89	AUG 1 1 2017	
QC	Memo	0.10							
Quality Control									

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AUG 1 1 2017

Picklist Print

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Parent Item: D350-636-012

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Start Date: 6/22/2017

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Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	5.0000	1	1			
D2600-3-BENT-RH									**			17-06-29	
Extrusion Bent RH													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG002			5					
					158774			5					
D2744		Manufactured	No			110	Each	20.0000	1	1			
D2744									**			BE170703	
Cap													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG001			20					
					159371			10					
					161732			10					
D2739		Manufactured	No			160	Each	11.0000	1	1			
D2739									**			17-06-11	
350 I Beam													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG002			11					
					159936			3					
					161380			8					

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

172.0000

8

8

D2743

Crossbolt Spacer

**

BE1707-13

Location

Loc Qty

Loc Code

LG001

172

150308
160400

62

110

8
8

D3490-3

Manufactured No

160

Each

83.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE1707-13

Location

Loc Qty

Loc Code

LG001

83

160393

83

4

D3490-1

Manufactured No

160

Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE1707-13

Location

Loc Qty

Loc Code

LG001

95

160394

95

4

D3631-1

Manufactured No

230

Each

159.0000

8

8

D3631-1

Washer

**

all 14/08/08

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

x8

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

20.0000

1

1

D3791-1

Wearpad

**

all 12/08/08

Location

Loc Qty

Loc Code

FP002

20

158753

10

161928

10

X1

D3793-3

Manufactured No

230

Each

29.0000

1

1

D3793-3

Wearplate Aft

**

all 17/08/09

Location

Loc Qty

Loc Code

FP002

29

159397

4

159871

25

X1

MS21043-6

Purchased No

230

Each

72.0000

4

4

MS21043-6

NUT

**

all 12/08/08

Location

Loc Qty

Loc Code

FG

20

103693

20

M1137963

YJ

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

D3794-1

Gasket Fwd

**

all 17/08/08

Location

Loc Qty

Loc Code

FP001

15

142770

1

150417

2

159376

12

XL

NAS1611-010

Purchased No

230

Each

203.0000

8

8

NAS1611-010

O-RING

**

all 12/08/08

Location

Loc Qty

Loc Code

FP001

203

m134955

7

m135603

8

m136182

4

m136836

84

m137587

100

11137963

Y8

D2741

Manufactured No

250

Each

47.0000

1

1

D2741

Replacement Blade

**

9-89 DAS

ALL 10/08/17 DAS 27 9-89

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

-37

132981

14

158915

23

DAS 28 9-89

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

**

20 17/08/08

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

359

m127831

20

m134508

3

m135600

2

m136263

4

m137361

330

ST266

4

X4

m130726

4

NAS1611-013

Purchased

No

230

Each

174.0000

8

8

NAS1611-013

**

20 17/08/08

O-Ring

Location

Loc Qty

Loc Code

FP001

174

11137963

X6

m137333

174

X2

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Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 147.0000 4 4

AN3C6A

Bolt

**

all 11/08/06

Location	Loc Qty	Loc Code
FG	10	
122416	10	M138040
FP001	21	
m136295	4	
m136781	17	
OVER002	96	
m137361	96	
ST350	20	
m128704	18	
m132767	2	

NAS1149C0832R Purchased No 230 Each 49.0000 1 1

NAS1149C0832R

Washer

**

all 12/08/09

Location	Loc Qty	Loc Code
FP001	49	
m135536	49	

D3536-25 Manufactured No 230 Each 27.0000 1 1

D3536-25

Gasket Center

**

all 12/08/09

Location	Loc Qty	Loc Code
FG	3	
95328	3	
FP001	24	
146747	2	
159368	4	
162506	18	

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Required Qty: 1.00

D3794-3

Manufactured No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

**

all 12/08/08

Location

Loc Qty

Loc Code

FP001

13

B163320

xl

159369

12

159924

1

AN3C5A

Purchased No

230

Each

928.0000

34

34

AN3C5A

Bolt

**

all 12/08/08

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

OVER002

200

M137710

200

ST350

66

M135442

66

x34

Thursday, June 22, 2017 10:20:35 AM

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Page 8

Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

all 12/08/08

Location

Loc Qty

Loc Code

FG

11

13163518

X3

79833

1

88562

10

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

D3535-25

Manufactured No

230

Each

18.0000

1

1

D3535-25

Wearplate Center

**

all 12/08/08

Location

Loc Qty

Loc Code

FG

1

148669

1

FP002

17

159879

7

161915

10

X1

D3492-3

Manufactured No

230

Each

218.0000

8

8

D3492-3

Plug

**

all 12/08/08

Location

Loc Qty

Loc Code

FP001

218

159296

136

162347

82

X8

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Page 8

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Page 9

Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

4,974.000

38

38

NAS1149C0332R

**

all w/08/08

WASHER

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

1137951

x38

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

D3488-042

Manufactured

No

230

Each

3.0000

1

1

D3488-042

**

all w/08/08

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

3

158787

3

B162374

x1

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Picklist Print

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Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

2,629.000

38

38

ALS4-1032-225

**

Rivnut

Location

Loc Qty

Loc Code

FG

25

M134975

20

M135998

5

FP001

2204

M135603

40

M135920

38

M135998

2115

M136265

11

ST556

400

M136579

400

138

D3492-1

Manufactured

No

230

Each

144.0000

8

8

D3492-1

**

Plug

Location

Loc Qty

Loc Code

FP001

144

158389

1

159298

63

161306

80

18

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

**

Wearplate Fwd

Location

Loc Qty

Loc Code

FP002

26

159358

4

159874

22

21

Picklist Print

Thursday, June 22, 2017 10:20:36 AM

Page 11

Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur-Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

124.0000

1

1

AN8C35A

Bolt

**

all 17/08/09

Location

Loc Qty

Loc Code

FG

3

121275

3

FP001

121

m133336

1

m134130

1

m134133

7

m137203

112

X1

MS21083C8

Purchased

No

230

Each

63.0000

1

1

MS21083C8

Nut

**

all 17/08/09

Location

Loc Qty

Loc Code

FP001

18

m137412

18

X1

ST297

45

m137361

25

m137820

20

D2745

Manufactured

No

230

Each

182.0000

8

8

D2745

Bushing

**

all 17/08/09

Location

Loc Qty

Loc Code

FP001

182

13163474

X0

159297

82

161760

100

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Page 11

Picklist Print

Thursday, June 22, 2017 10:20:36 AM

Page 12

Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH; Std Wearplates; DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

17/08/08

Location

Loc Qty

Loc Code

FP001

78

m132556

78

X4

over009

250

m137055

250

ST333

48

m136658

48

D3532-1

Manufactured

No

250

Each

45.0000

2

2

D3532-1

Spacer

**

DAS
6
9-89

AUG 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST038

45

159312

45

2

MS21083C8

Purchased

No

250

Each

63.0000

2

2

MS21083C8

Nut

**

DAS
6
9-89

AUG 10 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

2

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Page 12

Picklist Print

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Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur-Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

264.0000

2

2

NAS1149D0863.J

Washer

**

DAS

6

9-89

AUG 10 2017
DAS 27
9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

118

125268

118

D3493-1

Manufactured

No

250

Each

39.0000

2

2

D3493-1

Washer

**

DAS

6

9-89

AUG 10 2017
DAS 27
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST037

29

159305

9

161754

20

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

Page 14

Thursday, June 22, 2017 10:20:36 AM

Work Order ID: 163173

163173

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

302.0000

2 2

AN8C21A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	4	
123966	2	
m132169	2	
over004	217	
m137162	217	
ST332	81	
m136262	1	
<u>m137162</u>	80	

2

DAS
27
9-89
AUG 10 2017

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN6C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 163173 115
1706-22

RELEASED
2013-08-13
W

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-14/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

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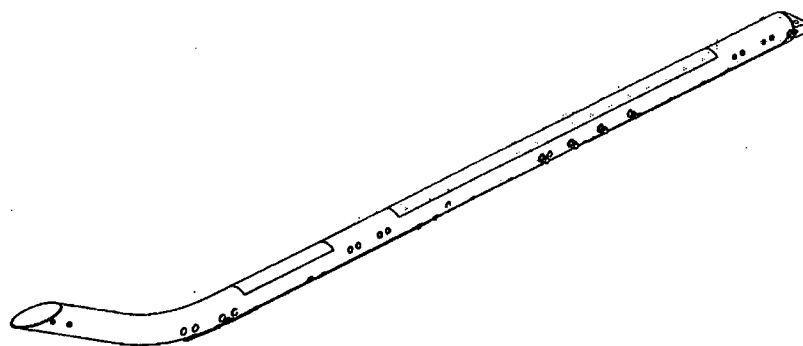
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REV. G

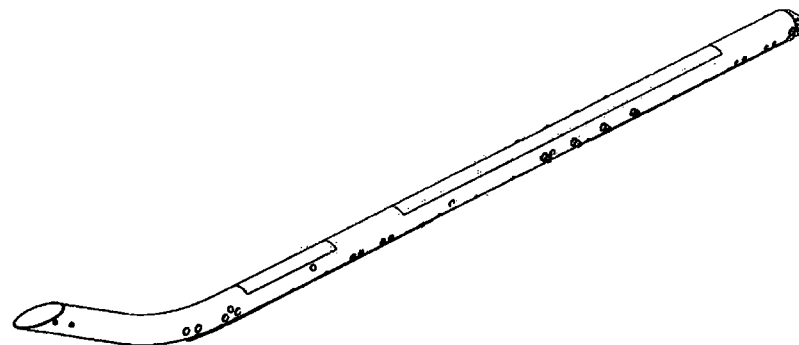
SHEET 1 OF 11

SCALE

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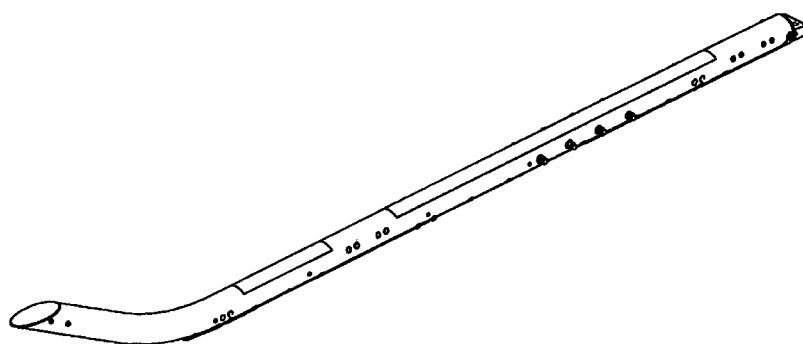
D2750-041 350 SKIDTUBE ASSEMBLY, LH



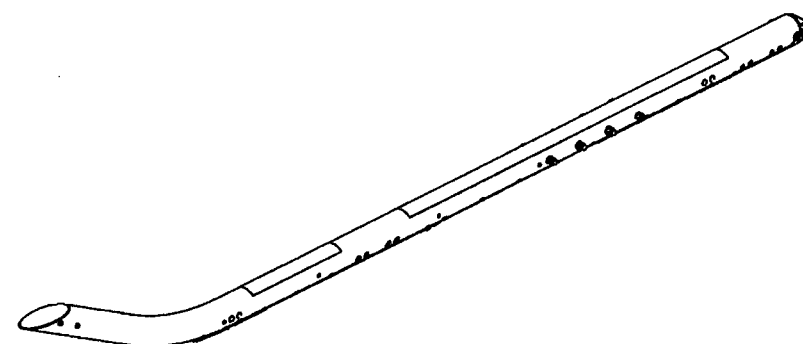
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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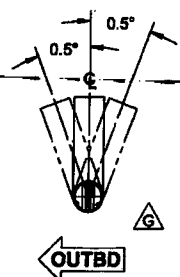
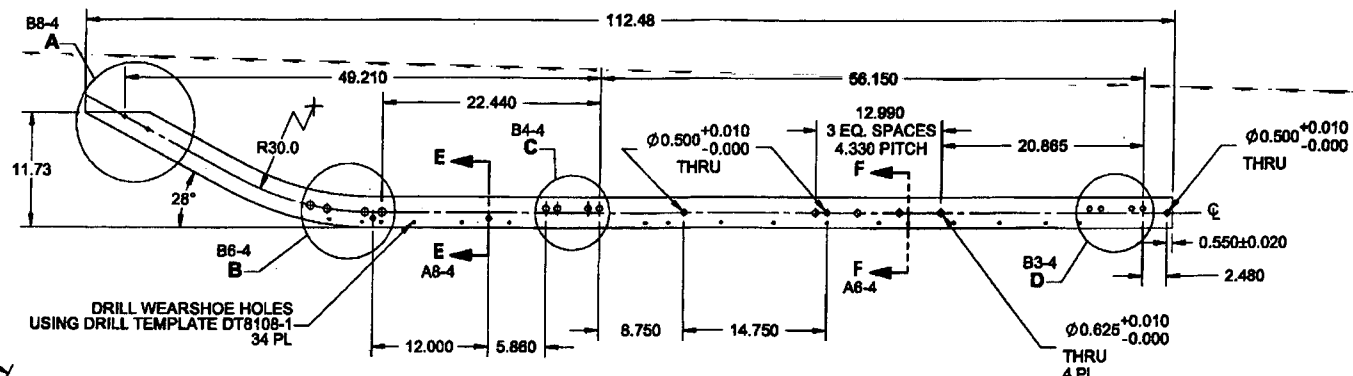
D2750-043 350 SKIDTUBE ASSEMBLY, LH



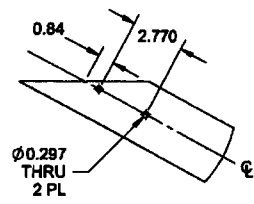
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
MP

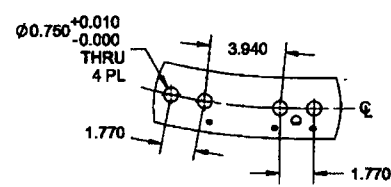
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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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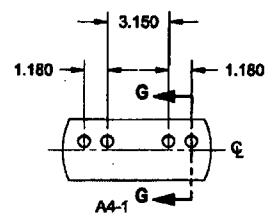
D2750-1 LH SKIDTUBE



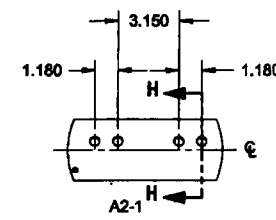
DETAIL A
SCALE 2X



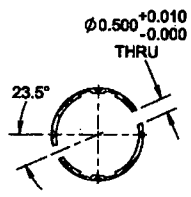
DETAIL B
SCALE 2X



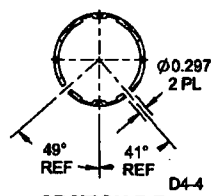
DETAIL C
SCALE 2X



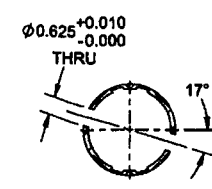
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SCALE 2X



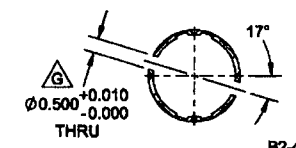
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

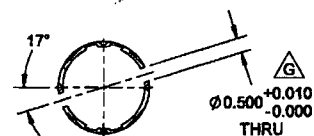
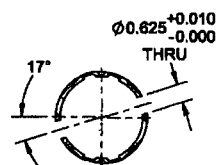
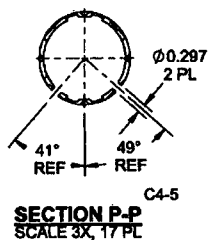
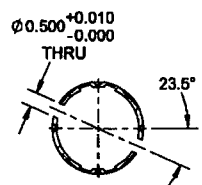
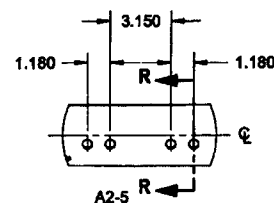
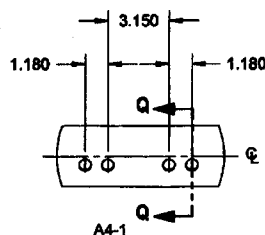
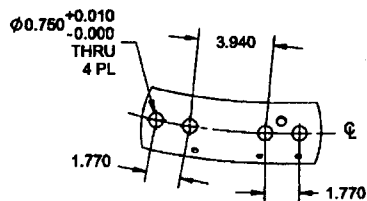
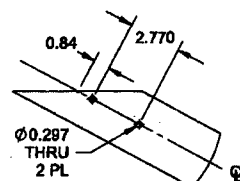
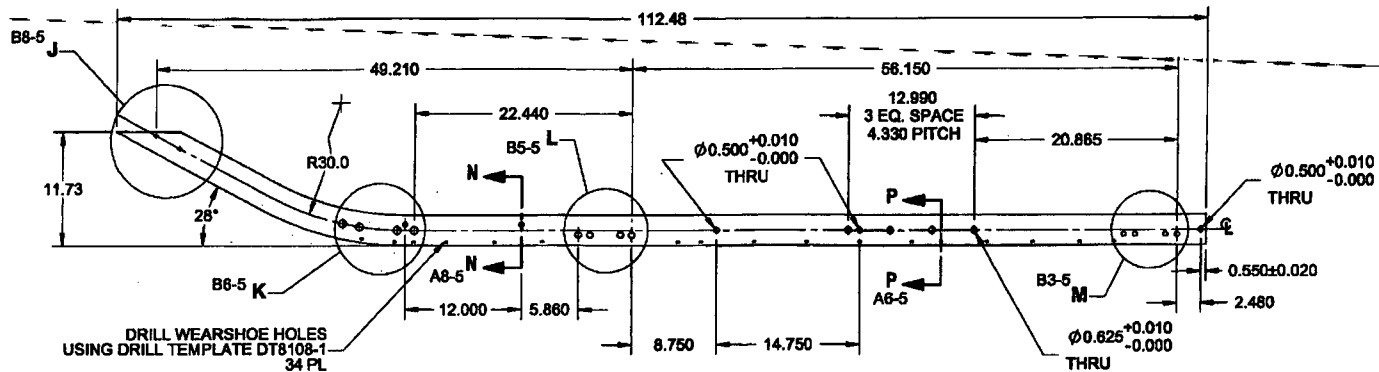


SECTION H-H
SCALE 3X, 4 PL

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2013-08-13

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DATE	13.07.11	NTS	

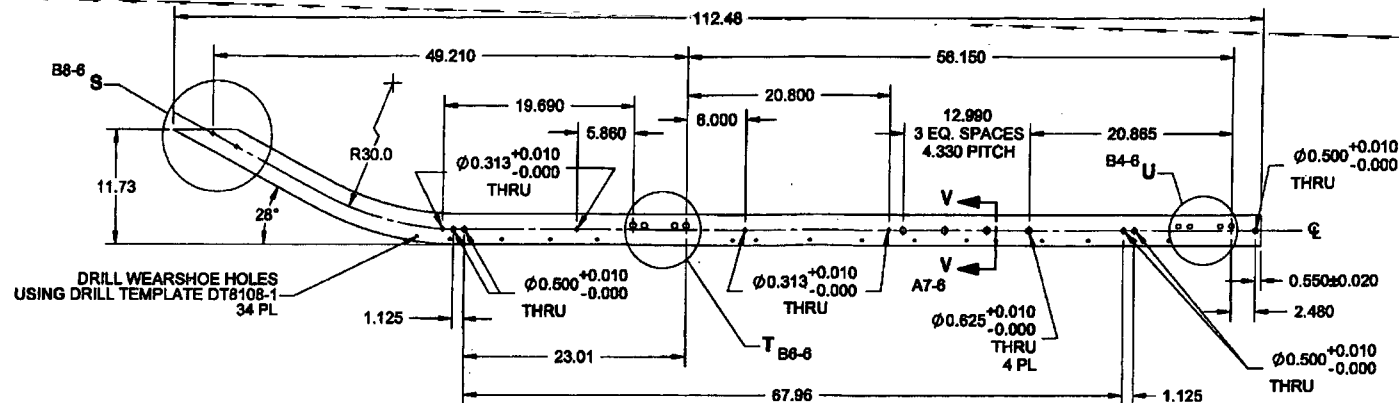
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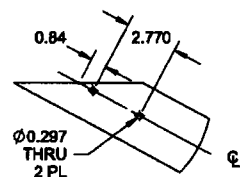
RELEASED
2013-08-13

SECTION R-R
SCALE 3X, 4 PL

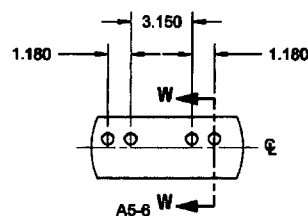
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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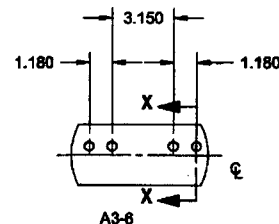
D2750-3 LH SKIDTUBE



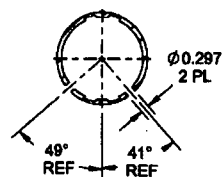
DETAIL S
SCALE 2X



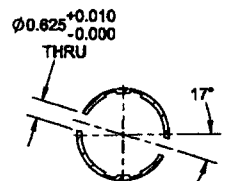
DETAIL T
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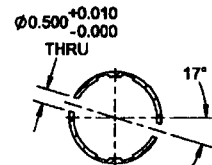
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



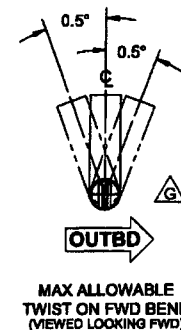
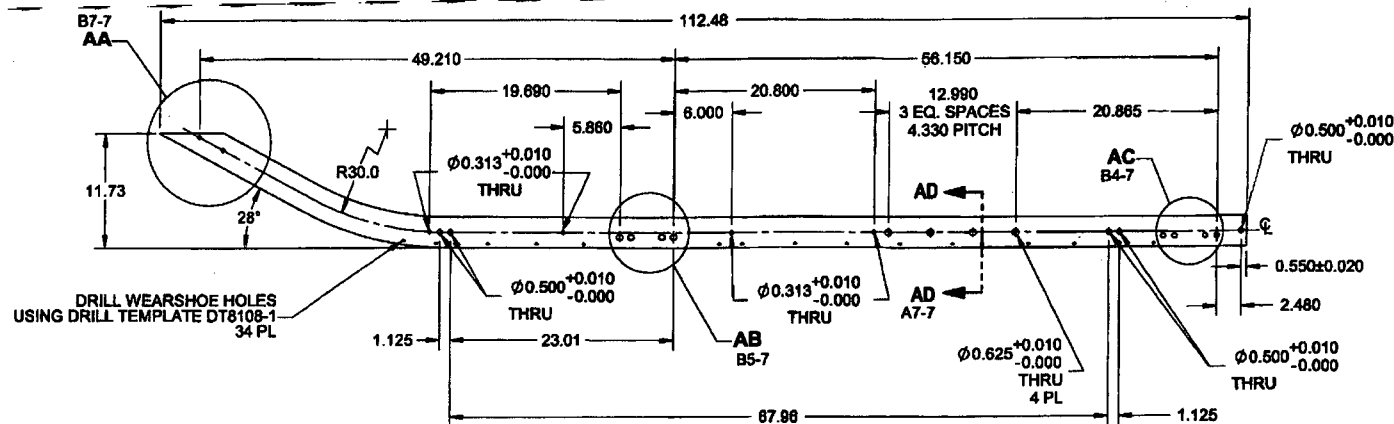
SECTION W-W
SCALE 3X, 4 PL



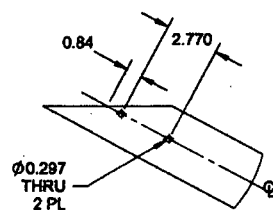
SECTION X-X
SCALE 3X, 4 PL

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2013-08-13

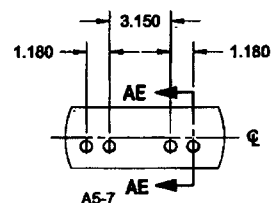
DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 6 OF 11	
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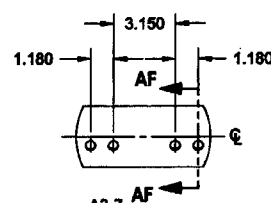
D2750-4 RH SKIDTUBE



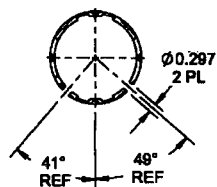
DETAIL AA
SCALE 2X



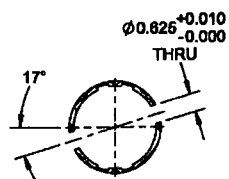
DETAIL AB
SCALE 2X



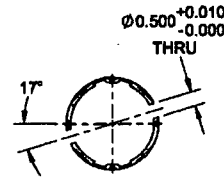
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

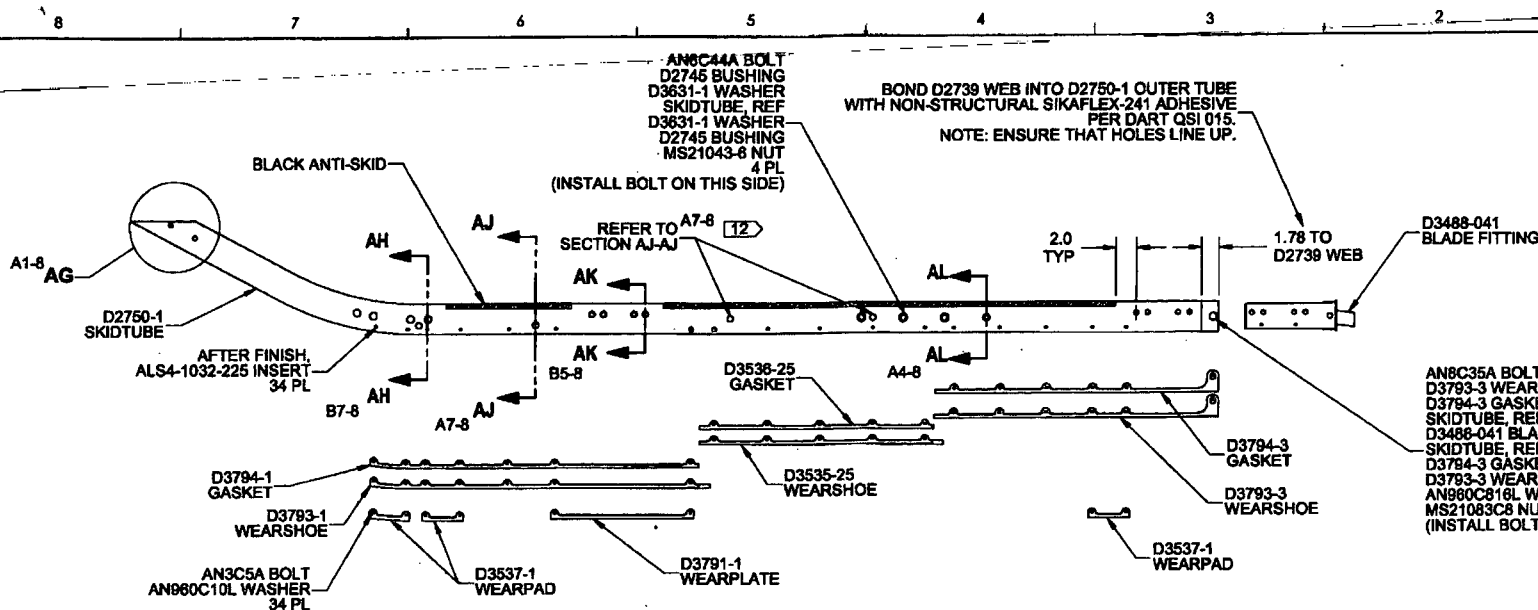


SECTION AF-AF
SCALE 3X, 4 PL

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2013-08-13

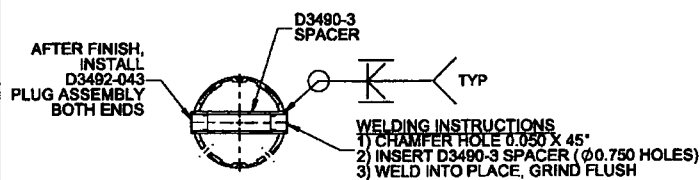
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CHECKED		
MFG. APPR.		
APPROVED		
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DATE	13.07.11	
DRAWING NO.	D2750	REV. G
TITLE	350 SKIDTUBE ASSEMBLY	SHEET 7 OF 11
SCALE	NTS	

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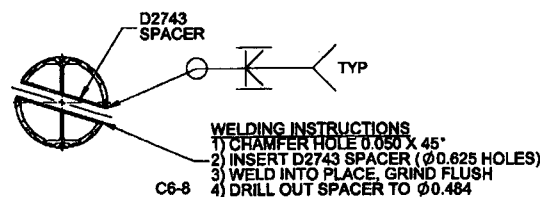


D2750-041 350 SKIDTUBE ASSEMBLY, LH

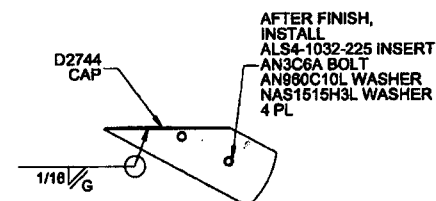
RELEASED
2013-08-13



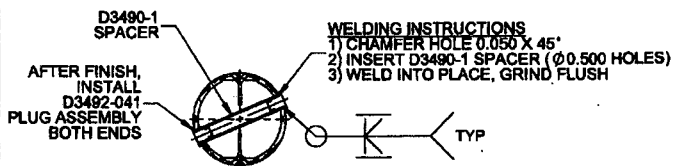
SECTION AH-AH
SCALE 3X, 4 PL



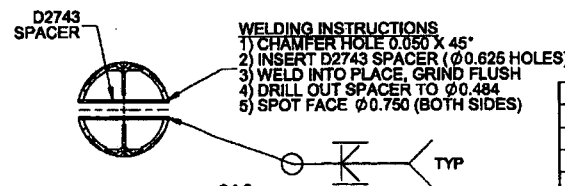
SECTION AK-AK
SCALE 3X, 4 PL



DETAIL AG
SCALE 2X



SECTION A-A
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
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A1-10

AS

BLACK ANTI-SKID

REFER TO SECTION AW-AW

D2750-3
SKIDTUBEAFTER FINISH,
ALS4-1032-225 INSERT
34 PLD3794-1
GASKETD3793-1
WEARSHOEAN3C5A BOLT
AN980C10L WASHER
34 PLD3537-1
WEARPADD3791-1
WEARPLATE

(INSTALL BOLT ON THIS SIDE)

AT

AU

AV

2.0
TYP1.78 TO
D2739 WEBD3488-041
BLADE FITTINGBOND D2739 WEB INTO D2750-3 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN980C818L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)**D2750-043 350 SKIDTUBE ASSEMBLY, LH**RELEASE
2013-08-13D2743
SPACER

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø 0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø 0.484

SECTION AT-AT
SCALE 3X, 4 PL

D6-10

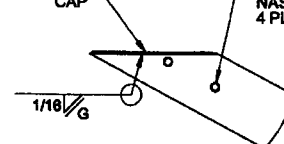


WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø 0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø 0.484
- 5) SPOT FACE Ø 0.750 (BOTH SIDES)

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D4-10

D2744
CAP

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C8A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

DETAIL AS
SCALE 2X

D8-10

D3490-5
SPACER

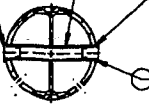
WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-5 SPACER (Ø 0.313 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

SECTION AU-AU
SCALE 3X, 4 PL

D5-10, D6-10

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS



WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

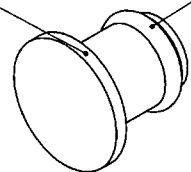
SECTION AW-AW
SCALE 3X, 4 PL

D4-10, D7-10

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
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MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



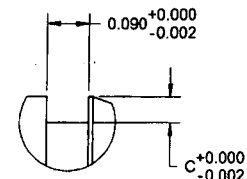
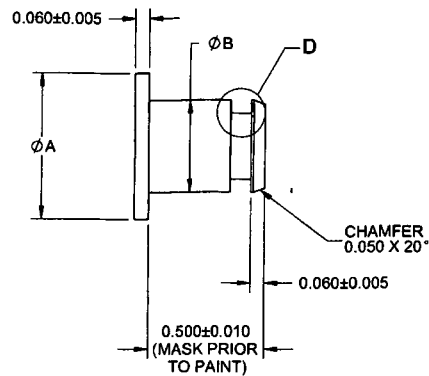
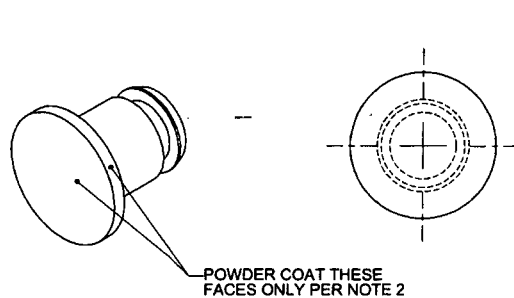
D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2013-11-13

REV.	DESCRIPTION	BY	DATE
E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	AP	D3492	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	NTS
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DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO. D3492	REV. E
MFG. APPR.	DS	SHEET 2 OF 2	
APPROVED	AP	TITLE	SCALE
DE APPR.	SH	PLUG	4:1
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RELEASED
2013-11-13

Work Order ID 163173

Thursday, June 22, 2017 10:20:32 AM

163173

Accept

N900040100

Setup Start *NS1*

Item ID: D350-636-012

Stop *NS2*

Revision ID:

Item Name: Skidtube R11 Std Wearplates DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date: JUN 22 2017

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750-042

G

D3492

E

AUG 1 0 2017

100

Document Control

0.00

DOCUMENT CONTROL

0.00

DAS
5
9-89

AUG 1 1 2017

100

DC

Memo

Doc. Control -USB or Paperwork

record fwd angle: _____

Photocopy blue file and type labels per PPP D350-636-012 CRG 007

United States of America
Department of Transportation - Federal Aviation Administration

Supplemental Type Certificate

Number SR00646SE

This certificate, issued to

Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402

*certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part * of the * Regulations.*

Original Product—Type Certificate Number:

Make:

Model:

* See attached Federal Aviation Administration (FAA) Approved Model List (AML) SR00646SE for approved aircraft models and applicable airworthiness regulations

Description of the Type Design Change: Replacement of the original landing gear skid tubes with DART D350-636 skid tube system components as appropriate. The D350-636 skid tube system must be fabricated in accordance with DART Aerospace USA, Inc. Master Document List (MDL) No. MDL-D350-636, Revision N, dated September 01, 2010, or later Federal Aviation Administration (FAA) approved Revision. The skid tubes must be installed in accordance with DART Aerospace Installation Instructions No. INN-D350-636, Revision H, dated July 26, 2010, or later FAA accepted revision. This modification must be maintained in accordance with DART Aerospace Instructions for Continued Airworthiness (ICA) No. ICA-D350-636, Revision 1, or later FAA-approved revision.

Limitations and Conditions: Approval of this change in type design applies to rotorcraft listed on the Approved Model List (AML) only. This approve should not be extended to other rotorcraft of these models on which other previously approved modification are incorporated unless it is determined by the installer that the relationship between this change and any of those other previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of the rotorcraft.

A copy of this Certificate, AML No. SR00646SE, and the ICA must be maintained as part of the permanent records for the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: April 24, 1998

Date reissued: October 28, 2015

Date of issuance: November 19, 1998

Date amended: September 27, 2010



By direction of the Administrator

Andrew Brown
(Signature)

Manager, Seattle Aircraft Certification Office
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.